

Work Order ID 147167

June 06, 2016 9:22:35 AM

U/R

147167

Need Qty 1 to ship ASP.

Bell Order.

Page 1

Item ID: D3608-1

Revision ID: URF 16-532

Item Name: Lower Doubler

Start Date: 6/6/2016 Start Qty: 4.00

Required Date: 6/7/2016 Req'd Qty: 4.00

Reference: Bell Order

Approvals: Process Plan: *Stt*

QC: _____

Date: 6/6/15

Date: _____

Tooling: _____

SPC (Y/N): _____

N9000040100

Cust Item ID:

Customer:

Setup Start

Stop

NS1

NS2

Run Start

Stop

NR1

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3608	CUT OK 6/16/17								PR 06/07/2016
100	FLOW WATER JET	0.00				8			
100									
Waterjet		0.18							
FLOW CNC Waterjet									
									
	Memo								
	1-Cut as per Dwg D3608								
	Dwg Rev: <i>E</i>								
	Prog Rev: <i>E</i>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00				8			12/16/16/08
110									
QC		0.01							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC		0.01							
Quality Control									

QAS
38
9-89

JUN 09 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only



Work Order: <u>147167</u> Part No. <u>D3608-1</u> NCR No. _____		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☒ Quality ☐ Other ☐					
Date: <u>16/6/7</u>		Step #: <u>160</u>		QTY Effective: _____			MRB (QSI042) Approval DAS 12 9-89		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
FOR BELL HEULWATER.				Do <u>not</u> drill gty (3) holes as shown on attached marked-up dwg.					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER: _____							

Work Order ID 147167

147167

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Item ID: D3608-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: URF 16-532 Stop ***NS2***
Item Name: Lower Doubler
Start Date: 6/6/2016 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 6/7/2016 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location:	0.00							
150	Pat Duval's Office								
Packaging	Memo	0.01				(8)	160615		
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.07							
Quality Control									

ML5 JUN 15 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : ☐									

Picklist Print

June 06, 2016 9:22:41 AM

Page 1

Work Order ID: 147167

147167

Parent Item: D3608-1

D3608-1

Parent Item Name: Lower Doubler

Start Date: 6/6/2016

Required Date: 6/7/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-03-26 JLM
IPP Rev:B 08-10-15 preliminary issue DD verified by:EC
IPP Rev:C 08-12-11 rev.A as per dwg DD verified by:EC IPP
Rev:D 10.02.16 rev.B as per dwg DD verified by:EC IPP Rev:E
10.11.17 as per PC1 dwg DD verified by:EC IPP Rev:F 10.11.29 as
per revC dwg DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased		No		100	sf	83.7210	0.7392	3.112421			

M304S20GA

304/316 .040 Sheet

PR 06/08/2016

Location	Loc Qty	Loc Code
MAT020	80.5	
m134399	4	
m134495	44.5	6.3
m134677	32	
MAT20	3.221	
m133901	3.221	

Under Review Notification

Raised By: M. BELLAVANCE

Product #: D412-775-013

Date: 16.02.25

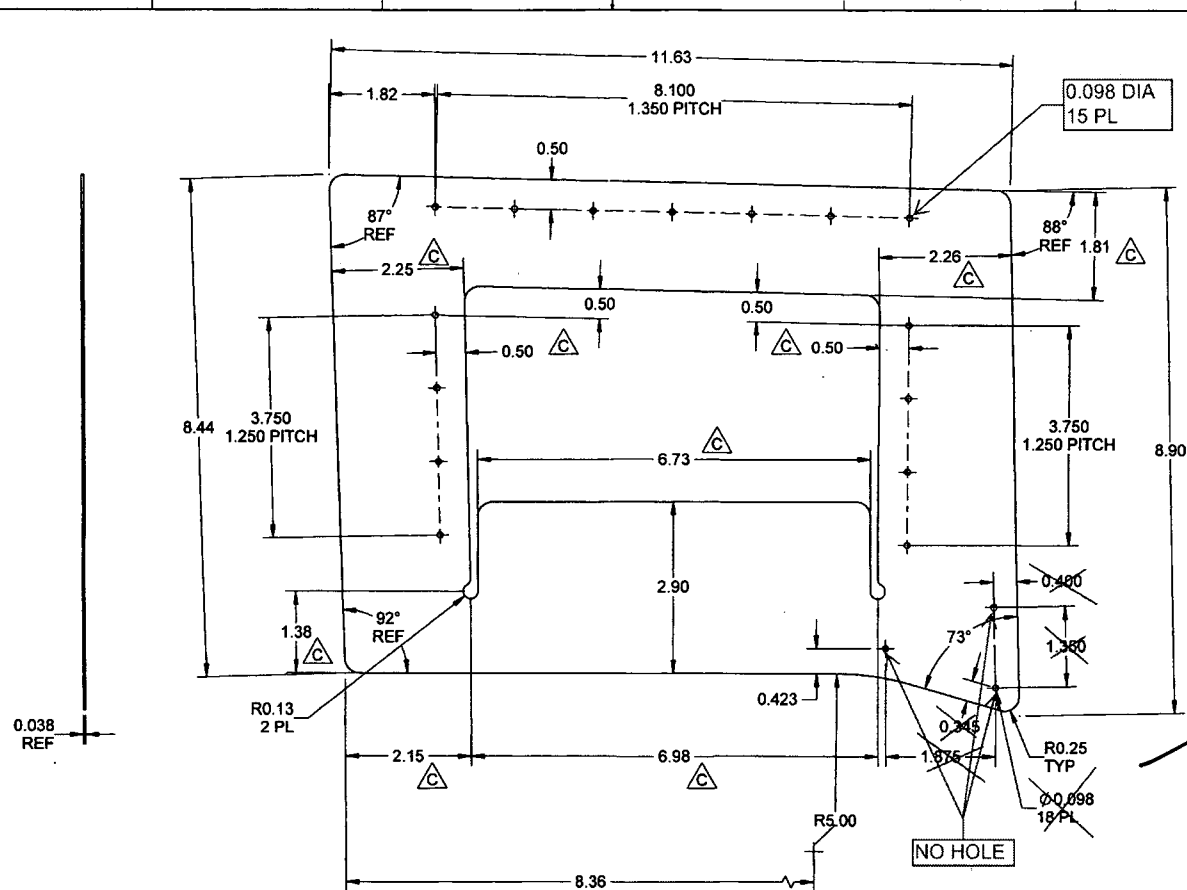
Product Name: STEP PROTECTIVE TRIM KIT

Part Number (D-Part and 9-Digit)	Drawing/Document & Current Affected Revision	"Y" or "N" Required for Each Part							Reserved ECN Log Number	Instructions Relevant to Each Part
		HOLD SHIPMENT	Red Tag/Quarantine Stock	Advise Customers	Stop Production	Re-Work Stock	IPP Under Review	Product Specifications Under Review		
D3608-1	D3608 Rev. C	N	Y	N	Y	N	Y	N	TBD	See below.
D412-775-013	IIN-D412-775 Rev. A	N	Y	N	Y	N	Y	N	16-532	See below.

Description of Issue:

Current stock OK to ship to customers other than Bell Helicopter Mirabel.

If shipping to Bell Helicopter Mirabel: must ship D412-775-013 with D3608-1 minus 3 holes as per attached. Eng. to sign off deviations on W/Os.



No hole 3
Pluses GP 14/6/7 B

RELEASED
2010-11-23

D3608-1 LOWER DOUBLER

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 20 GAUGE
PER MIL-S-5059, OR AMS 5513 (304) OR AMS 5524 (316)
OR ASTM A240 OR ASTM SA240
REF DART SPEC M304S20GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.76 lbs

C	OFFSET TOP AND VERTICAL EDGES OF RECTANGULAR OPENING BY 0.250 OUTWARDS; UPDATE IDENTIFICATION REFERENCE	MB	10.11.19
B	OFFSET TOP AND VERTICAL EDGES OF RECTANGULAR OPENING BY 0.250 INWARDS; ELIMINATE D3608-1F1-3F; DELETED BENDING DETAILS. REASON: D3608-1/3 NOW SOLD TO CUSTOMERS UNBENT PER PAR#09-087	MB	10.02.05
A	NEW ISSUE	MB	07.04.11
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.11.19		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

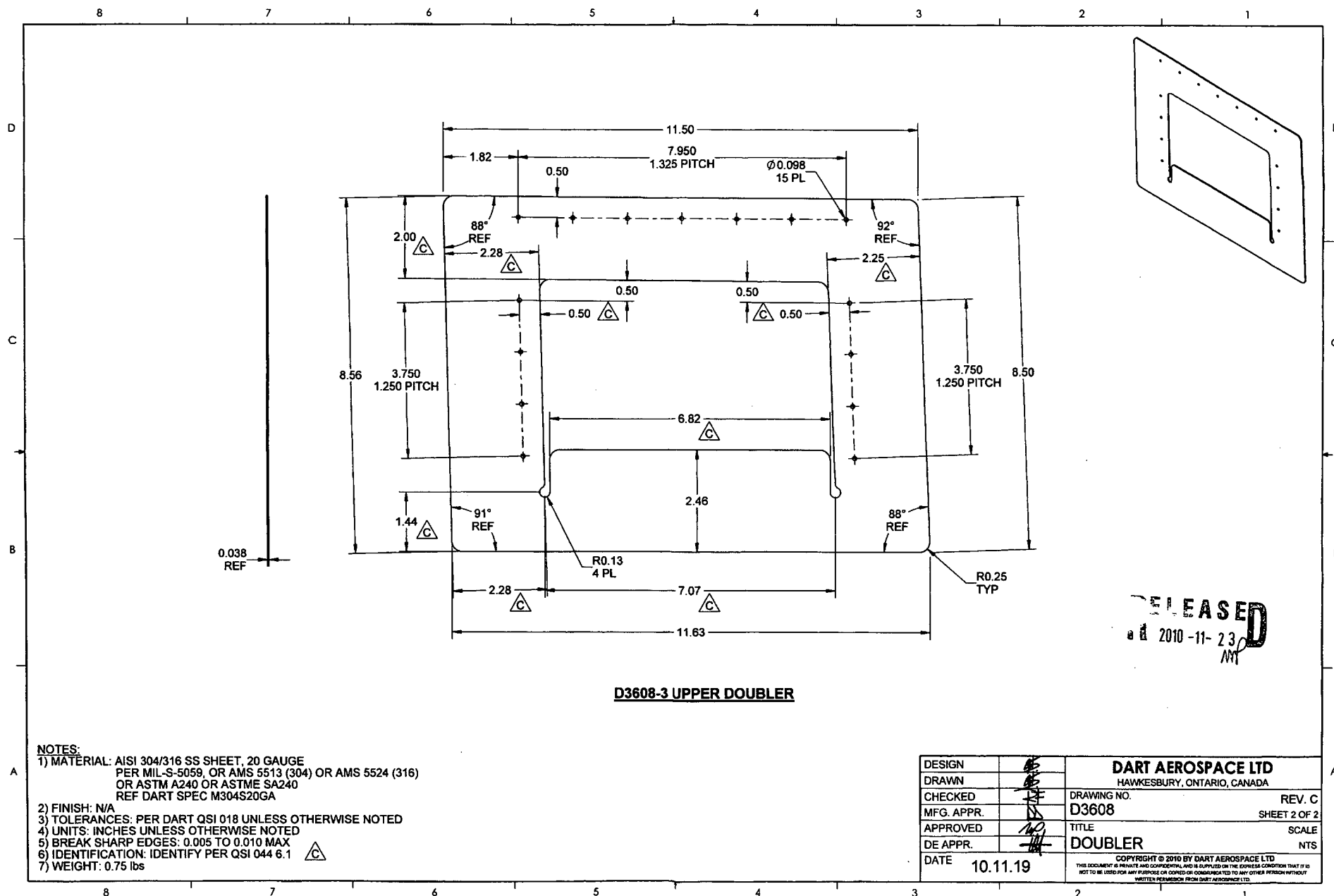
DRAWING NO.
D3608

REV. C
SHEET 1 OF 2

TITLE
DOUBLER

SCALE
NTS

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DART AEROSPACE LTD	Work Order: 147167
Description: Lower Doubler	Part Number: D3608-1
Inspection Dwg: D3608 Rev: C	Page 1 of 1

INSPECTION SHEET

[illegible]

Measured by: PR		Checked by: 38		QC Inspector:	
Date: 06/08/2016		Date: JUN 09 2016		Date:	

Engineering Approval: (If necessary)		Date:	
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(If necessary)			Revised by	Approved
Rev	Date	Change	KJ	
B	14.07.31	New Issue		